Date: Wednesday, 12/11/2008 1:38:07 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: COMFORT SEAT- FRAME
Job Number	: 43359		
Estimate Number	: 13369		
P.O. Number	:	**Part Number**	: D37521
This Issue	: 12/11/2008 **S.O. No.** :	**Drawing Number**	: D3752
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : THERMOFORMING	**Drawing Revision**	: C
Previous Run	: 43358	**Material**	:
Written By	:	**Due Date**	: 08/12/2008 **Qty:** 1 **Um:** Each
Checked & Approved By	: JVD 08.12.12		
Comment	: Est. REV: A New Issue 08.06.03 DL verified by:DD		
	Est Rev. B Dwg. Update 08/07/22 DL		
	Est. Rev. C Dwg. Update Shorter length 08/10/28 DL		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING

Set up machine program D3752-1
Set up clamping frame as per folio DL 08/11/13

2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET

Comment: Qty.: 10.6670 sf(s)/Unit Total : 10.6670 sf(s)
GE PLASTICS LEXAN SHEET

Batch # M109455 BB 08/11/13 (X1)

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks BB 08/11/13 (X1)

4.0	THERMOFORMING	THERMOFORMING MACHINE

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3752 and Folio #3

Dwg. Rev. C
Folio Rev. C BB 08/11/14 (X1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:38:07 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** COMFORT SEAT- FRAME

Job Number: 43359 **Part Number:** D37521

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/11/17 (X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0	HAND FINISH TH	HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions BB 08/11/17 (X1)

7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances. BB 08/11/17 (X1)

8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP S 08/11/17 (X1)

9.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1 ST263 08/11/18 (X1)

10.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 08/11/18

Job Completion MF 08-11-18

Form: rprocess

Dart Aerospace Ltd

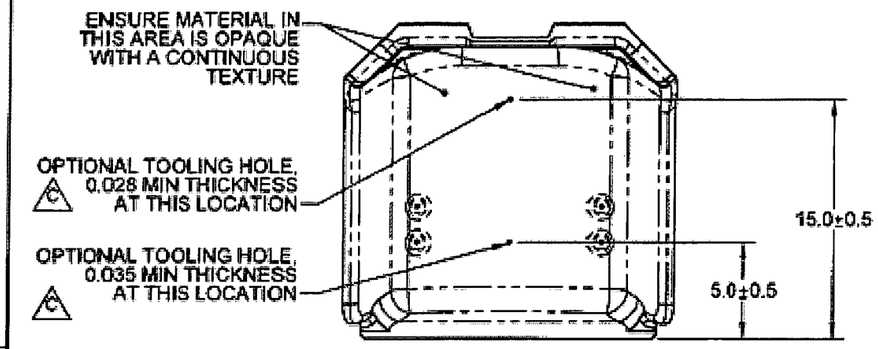
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

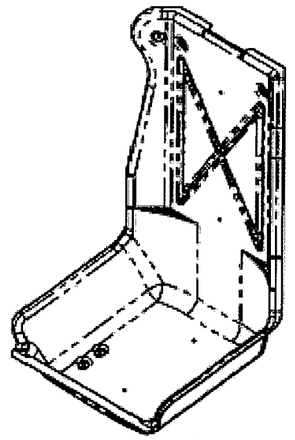
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

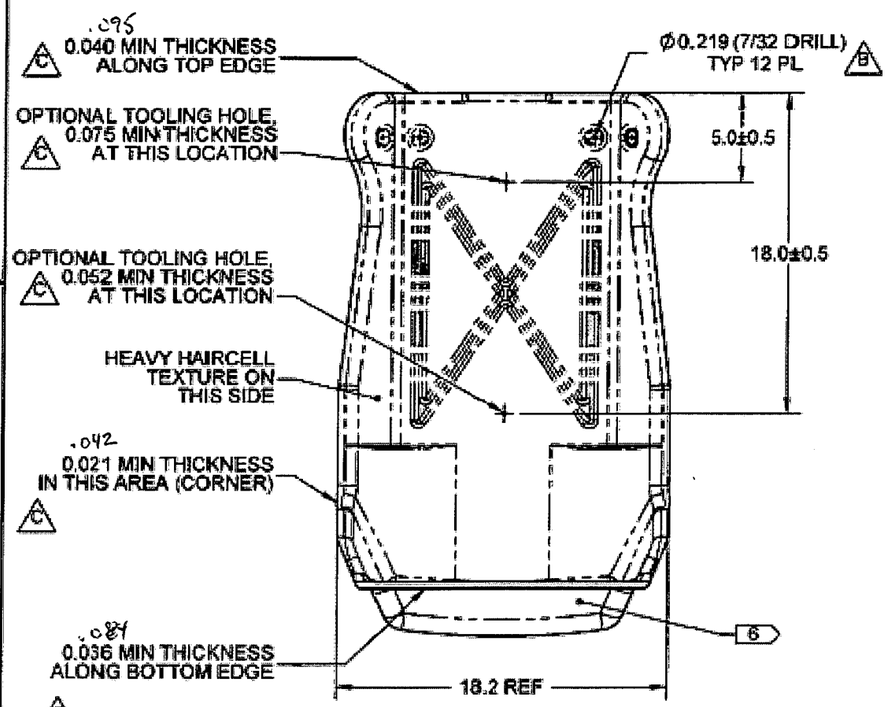
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

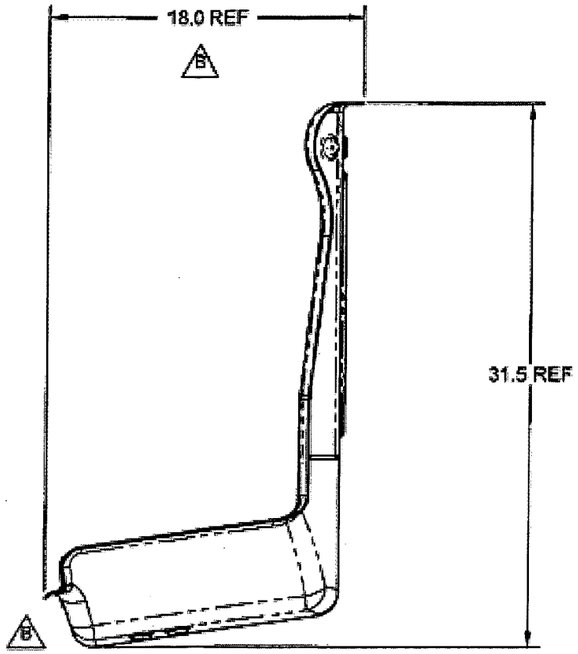
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries









D3752-1 SEAT FRAME

NOTES:
1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
7) WEIGHT: 3.0 lbs
8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 243359

RELEASED
08/11/08

REV.	DESCRIPTION	BY	DATE
C	REDUCE THICKNESS: 0.040 WAS 0.050 (ZN C8-1), 0.075 WAS 0.100 (C8-1), 0.052 WAS 0.090 (B8-1), 0.021 WAS 0.030 (B8-1), 0.036 WAS 0.060 (A8-1), 0.028 WAS 0.035 (D8-1), 0.035 WAS 0.050 (D8-1). SOME HOLES NOW OPTIONAL (A8-1 TO D8-1)	CP	08.10.08
B	FRONT PORTION NOW SHORTER (B5-1). 18.0 WAS 19.6 (C4-1). 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (D8-1, B8-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3752 REV. C
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE SEAT FRAME
DE APPR.		SCALE NTS
DATE	08.10.08	

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DART AEROSPACE LTD	WORK ORDER:	43359
Description: Seat Frame	Part Number:	D3752-
Inspection Dwg: D3752 Rev: C		Page 1 of 11

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	✓
Free of visual flaws (bumps, cracks, voids, etc.	✓

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____Rev. __ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.028"	MIN	.050	✓			
0.035"	MIN	.059	✓			
0.040"	MIN	.095	✓			
0.075"	MIN	.106	✓			
0.052"	MIN	.074	✓			
0.021"	MIN	.042	✓			
0.036"	MIN	.084	✓			

Measured by:	BD
Date:	08/14/17

Audited by:	C
Date:	08/14/17

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
		New Issue		